

Work Order ID 110777

January-07-14 3:03:14 PM

110777

Page 1

Item ID: D3536-13

D 3536 - 13

Accept

N900040100

Setup Start

NS1

Revision ID:

B 110777

Item Name: Gasket Fwd

Start Date: 1/07/14 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/07/14 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 14-01-08

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3536	Rev A
-------	-------

100

100

Waterjet

FLOW CNC Waterjet

Rev .063

FLOW WATER JET

Memo

0.00

1-Cut as per Dwg D3536 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

13 0 Jan 14-01-15

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

13 0 Jan 14-01-15

120

120

QC

Quality Control

QC8- Inspect parts - second check

0.00

DAS

27

9.89

0.00 14/1/15

13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____
 Part No. _____
 NCR No. _____

DISPOSITION

Rework
 Scrap
 Use-as-is
 Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

Skid-tube
 Machining
 Thermoforming
 Large Fab

Crosstube
 Small Fab
 Finishing
 Composite

Water Jet
 Prod. Eng. Coor.
 Rec/Store/Packaging
 Supplier

Engineering
 Quality
 Other

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General													
	Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>									
	Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>									
	Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>									
	Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>									
	Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>									
	Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>										
	Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>									
	Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>											
	Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>											
	Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>											
	Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>											

Work Order ID 110777

110777

Page 2

January-07-14 3:03:14 PM

Item ID: D3536-13

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Gasket Fwd

Stop

NS2

Start Date: 1/07/14 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/07/14 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

130

Identify as per dwg & Stock Location: F12-001

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Packaging

Packaging

Memo

0.00

x13 4 21 14/01/15

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

14-01-15

14-01-15

DQA:

Date: _____



QA Closed:

Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS								
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering							
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>			Quality <input type="checkbox"/>					
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Supplier <input type="checkbox"/>					
	Suspected Unapproved <input type="checkbox"/>											
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector	
Design												
Doc/Data												
Equip/Tooling												
Handling/Pre												
Material												
Operator												
Offset/Setup												
Process												
Supplier												
Training												
Transport												
Unapproved												
FAULT CATEGORY												
Landing Gear	General			Folio/Program			Outside Dimensions			Pressure/Forced		
	Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Part Moved <input type="checkbox"/>
	Cracks <input type="checkbox"/>	Burrs <input type="checkbox"/>	Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Contamination <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Countersink <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>
	Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Drawing <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Weld <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>
	Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Heat Treat <input type="checkbox"/>	Drawing <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Finish <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Other <input type="checkbox"/>	
	Heat Treat <input type="checkbox"/>	Drawing <input type="checkbox"/>	Inspection Strip in Tube <input type="checkbox"/>	Finish <input type="checkbox"/>	Fit/Function <input type="checkbox"/>							
	Inspection Strip in Tube <input type="checkbox"/>		Marks/Chatter <input type="checkbox"/>									
	Marks/Chatter <input type="checkbox"/>		Turning Sequence <input type="checkbox"/>									
	Turning Sequence <input type="checkbox"/>		Wave/Twist in Tube <input type="checkbox"/>									
	Wave/Twist in Tube <input type="checkbox"/>											

Picklist Print

January-07-14 3:03:13 PM

Page 1

Work Order ID: 110777

Parent Item: D3536-13

Start Date: 1/07/14

Required Date: 1/07/14

Parent Item Name: Gasket Fwd

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 NEOPRENE SHEET 0.063		Purchased	No			100	sf	121.4000	0.8269	5.5126668 10		JM14-07-15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT052		121.4							
					M126546		121.4			126546			

DQA:

Date: _____



QA Closed:

Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS						
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>					
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>					
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>					
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>						
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Design										
Doc/Data										
Equip/Tooling										
Handling/Pre										
Material										
Operator										
Offset/Setup										
Process										
Supplier										
Training										
Transport										
Unapproved										
FAULT CATEGORY										
Landing Gear	General									
	Bending	Bend	Folio/Program						Outside Dimensions	Pressure/Forced
	Centre Not Concentric	BOM/Route	Grain						Over/Under tolerance	Set-up
	Cracks	Broken/Damage/Defect	Hardware						Part Incorrect	Temperature/Cure
	Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified						Part Lost/Missing	Weld
	Cuffs	Contamination	Instructions Incomplete/Unclear						Part Moved	Wrong Stock Pulled
	Crushing	Countersink	Misaligned/off center						Positioned Wrong	
	Heat Treat	Cut Too Short	Mislabeled						Power Loss/Surge	Other
	Inspection Strip in Tube	Drawing	Misread							
	Marks/Chatter	Drill Holes	Off-set							
	Turning Sequence	Finish	Out of Calibration							
	Wave/Twist in Tube	Fit/Function	Out of Sequence							

DART AEROSPACE LTD		Work Order:	110777
Description: Gasket		Part Number:	D3536-13
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

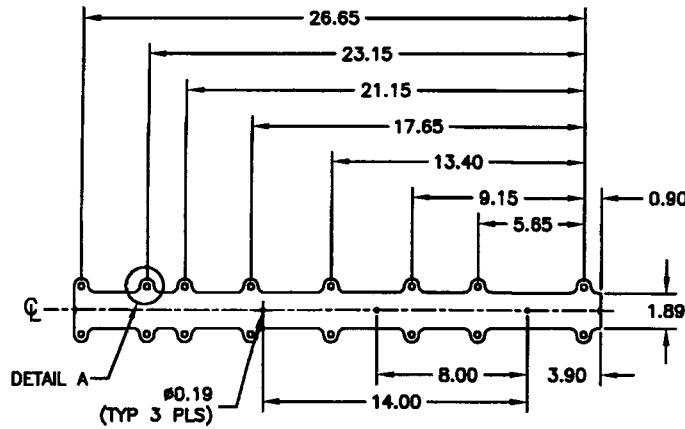
FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.90	+/-0.030	32.90"	—		T	Jm
29.40	+/-0.030	29.40"	—		T	
27.40	+/-0.030	27.40"	—		T	
23.90	+/-0.030	23.90"	—		T	
18.98	+/-0.030	18.98"	—		T	
14.07	+/-0.030	14.07"	—		T	
9.15	+/-0.030	9.15"	—		T	
5.65	+/-0.030	5.65"	—		V	
3.90	+/-0.030	3.90"	—		V	
8.00	+/-0.030	8.00"	—		V	
14.00	+/-0.030	14.00"	—		T	
20.00	+/-0.030	20.00"	—		T	
1.89	+/-0.030	1.89"	—		V	
0.30	+/-0.030	0.30"	—		V	
0.30	+/-0.030	0.30"	—		V	
Ø0.19	+0.005/-0.001	0.19"	—		V	

Measured by:	Jm	Audited by:	27	Prototype Approval:	N/A
Date:	14-01-15	Date:	14/1/15	Date:	N/A

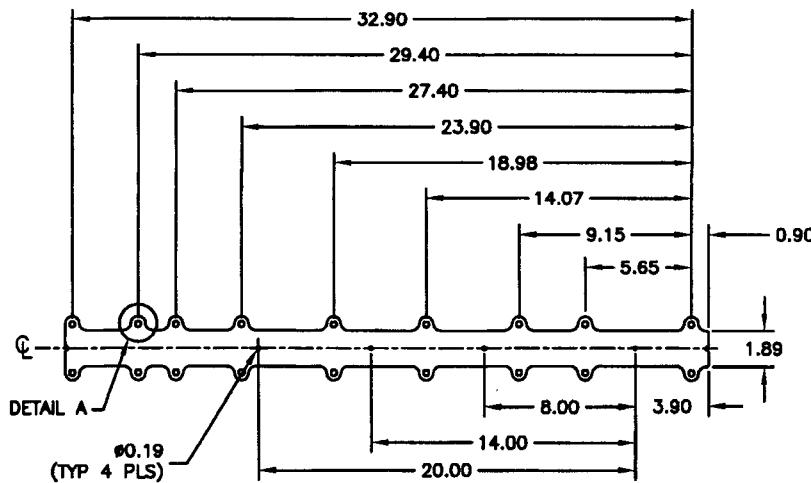
Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	EE



D3536-11 GASKET

110777 MJD

14-01-08



D3536-13 GASKET

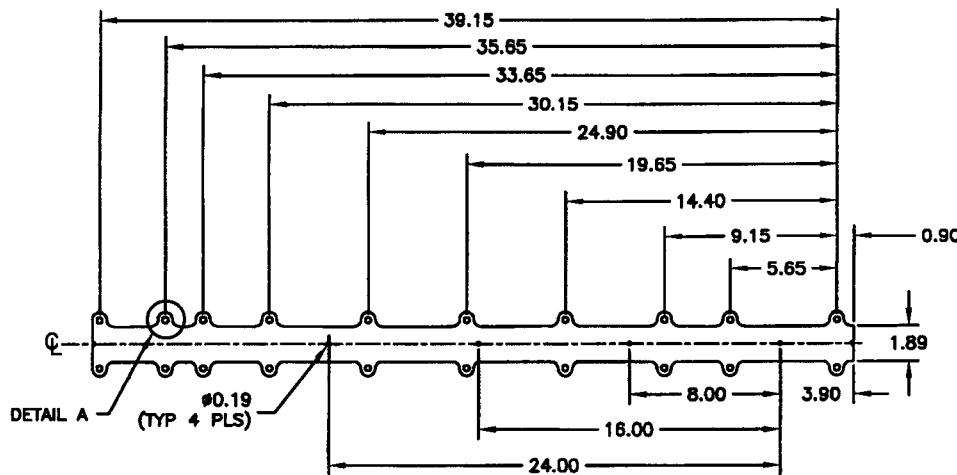
NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

09-02-12
RELEASED

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	CB	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3536
DATE		SCALE
06.10.25		1:10
A	06.10.25	NEW ISSUE
		SHEET 1 OF 6

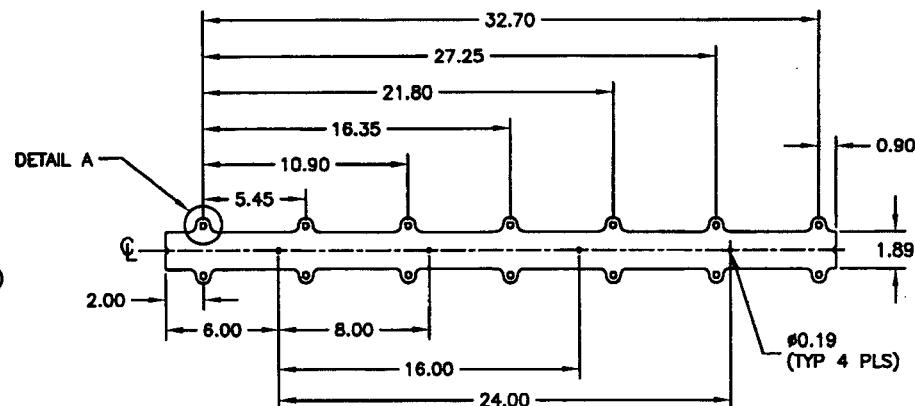
DART**RELEASER**
07.02.12**D3536-15 GASKET**

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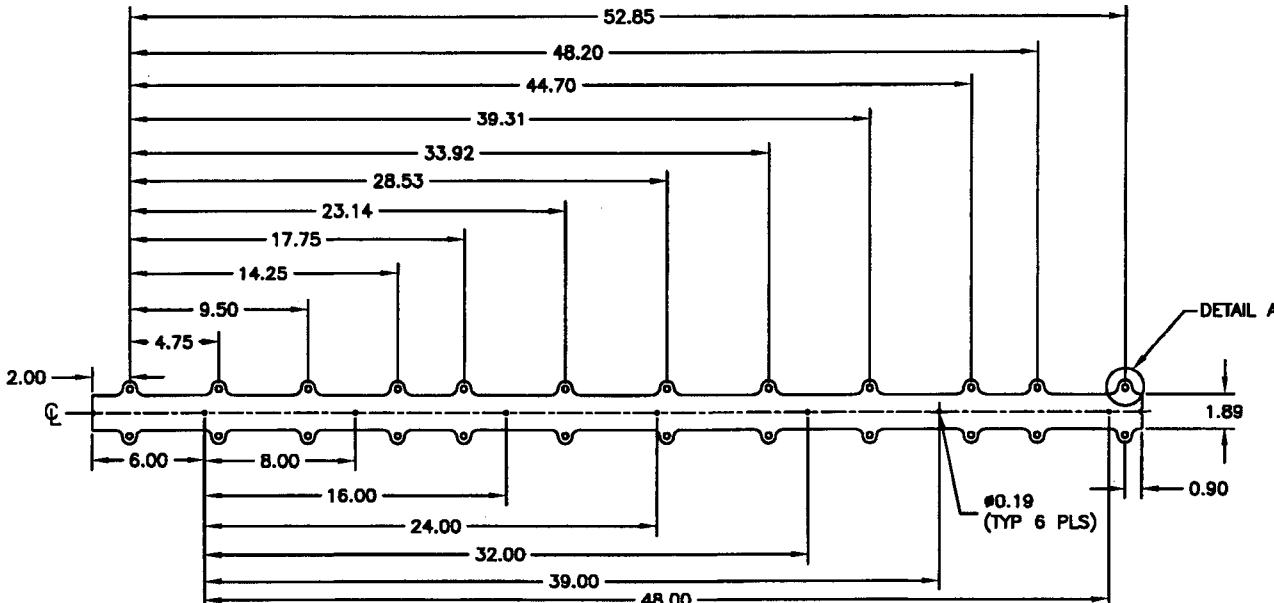
NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

**D3536-21 GASKET**

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DATE 06.10.25	TITLE GASKET	SCALE 1:10

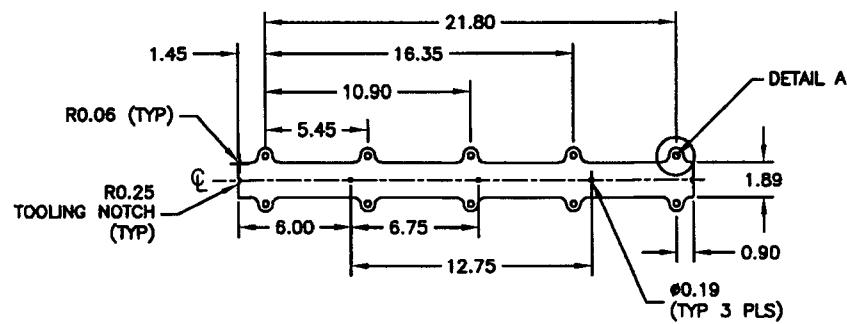
REV. A
SHEET 2 OF 6



D3536-23 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-25 GASKET

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
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CHECKED	APPROVED	REV. A
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06.10.25		SHEET 3 OF 6
		SCALE
		1:10
		TITLE
		GASKET

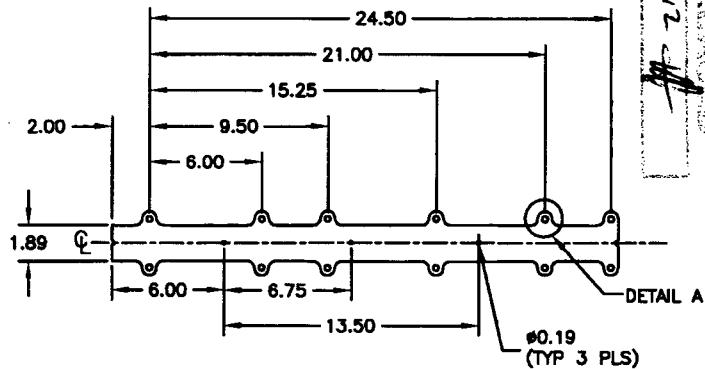
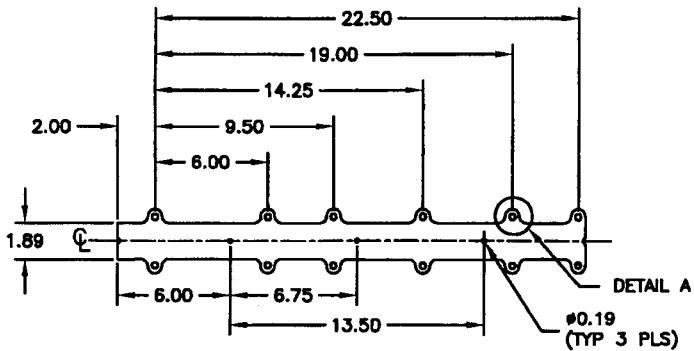
07.02.12
07.02.12

DART

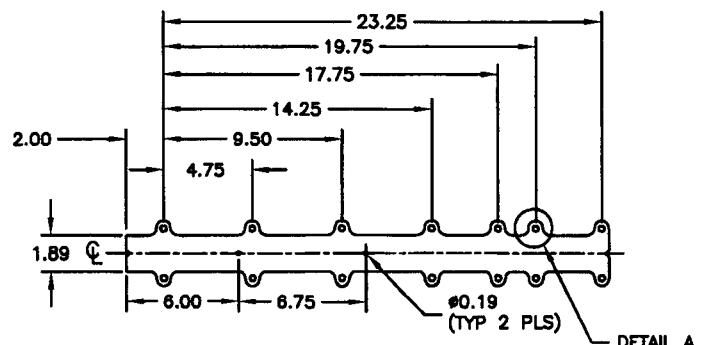
DART

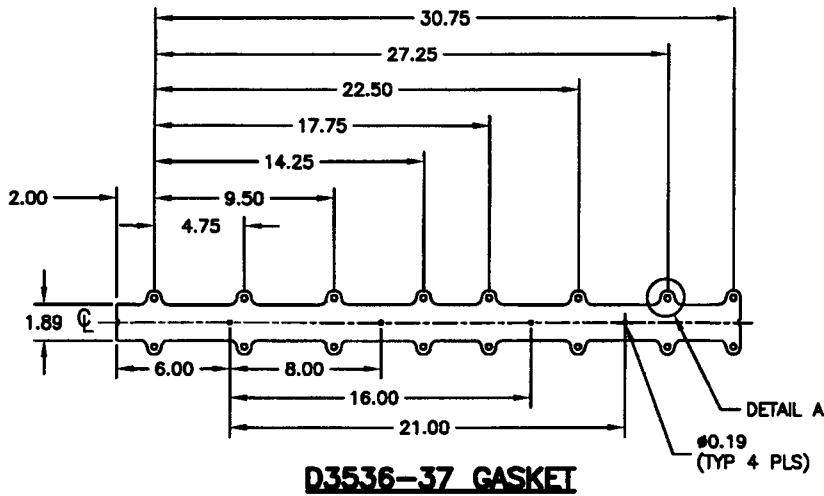
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CHECKED M	APPROVED M	DRAWING NO. D3536
DATE 06.10.25		TITLE GASKET
		REV. A SHEET 4 OF 6 SCALE 1:10

07.02.12
DART AEROSPACE USA, INC.

**D3536-33 GASKET****D3536-31 GASKET****NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

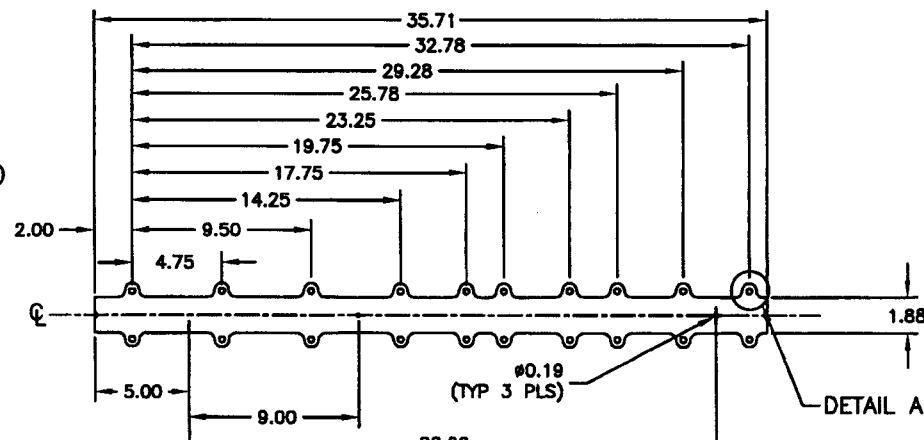
**D3536-35 GASKET**



D3536-37 GASKET

NOTES

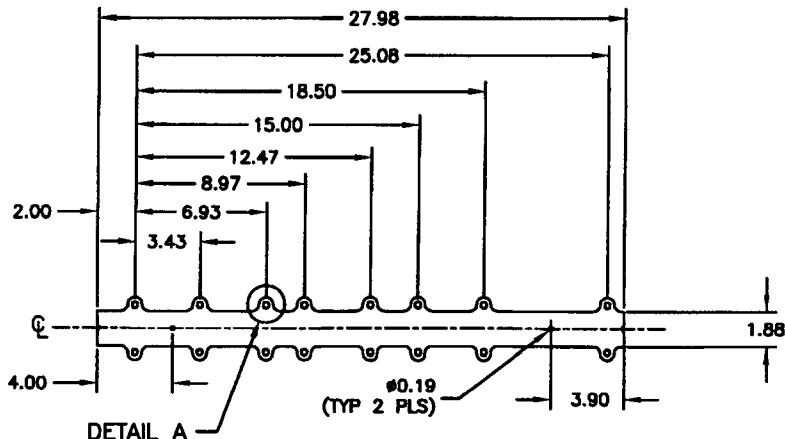
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-39 GASKET

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	CB	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3536
DATE		TITLE
06.10.25		GASKET
REV. A		SHEET 5 OF 6
SCALE		1:10

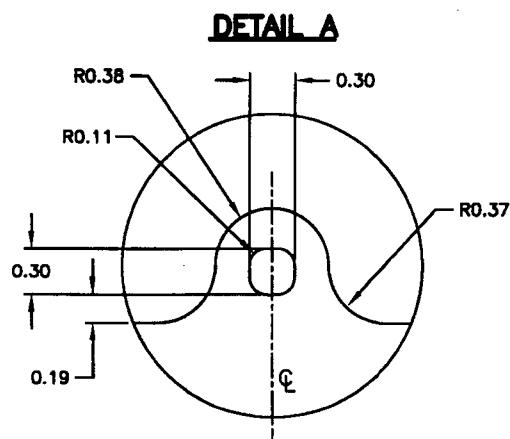
DART



D3536-41 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 01B UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C8	C8	PORT HADLOCK, WA
PH	PH	DRAWING NO.
06.10.25		D3536
		SCALE
		1:10
		SHEET 6 OF 6

DART

07.02.02